

Work Order ID 66983

Thursday, March 03, 2011 10:45:00 AM



Page 1

Item ID: D2857-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Bracket

Start Date: 3/3/2011 Start Qty: 24.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 24.00



Customer:

Reference:

Run Start



Approvals: Process Plan: 11-03-3 Date: 11-03-3 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2857	Rev C
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100

0.00



BAND SAW

0.00

Bandsaw
Jeaspa Bandsaw

Memo

Cut blanks 4.425"

SL 11/04/26

24

110

0.00



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

HAAS CNC vertical machine #1

Memo

1-Machine per folio FA940
FOLIO REV: AA
DWG REV: C
2-Deburr any rough edges

SL 11/04/28

24

120

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

SL 11/04/28

24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66983

Thursday, March 03, 2011 10:45:00 AM



Page 2

Item ID:	D2857-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Hinge Bracket					
Start Date:	3/3/2011	Start Qty:	24.00		Cust Item ID:	
Required Date:	3/11/2011	Req'd Qty:	24.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00				24	0		
Quality Control									

140	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00				24	0		11/05/09
Hand Finishing									

160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00				24	0		11/05/09
Powder Coating									

START TIME: 10:10
 OVEN TEMPERATURE: 320
 FINISH TIME: 10:40

M 116964

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 66983

Thursday, March 03, 2011 10:45:00 AM



Page 3

Item ID: D2857-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Bracket

Start Date: 3/3/2011 Start Qty: 24.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 24.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

24 0 24 11/05/09

180

Identify as per dwg & Stock Location: 24

0.00



Packaging

Memo

0.00

Packaging

11/5/95 (24)

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/11

11/05/10

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, March 03, 2011 10:45:07 AM

Page 1

Work Order ID: 66983



Parent Item: D2857-1



Parent Item Name: Hinge Bracket

Start Date: 3/3/2011

Required Date: 3/11/2011

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP C 00.06.22 Removed P/O for powder coat EC
 IPP D 06.05.01 Added level 8 EC IPP Rev:E
 10.06.10 remove seq150 DD verf:JLM IPP Rev:F 11.01.06 as
 per dwg revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6B2.000X01.25
0

Purchased

No

100

f

34.3055

0.37

9.347368



6061-T6 Bar 2.00 x 1.25



21 11/04/26

Location

Loc Qty

Loc Code

MAT

34.3055

114507

7.6555

114899

2.65

116623

24

9.35

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 46983
Description: Hinge Bracket		Part Number: D2857-1
Inspection Dwg: D2857	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.300	/		VERA 11-3	
4.000	+/-0.010	4.000	/		H-G	
0.340	+/-0.010	.340	/			
1.110	+/-0.005	1.110	/			
1.790	+/-0.010	1.790	/			
1.320	+/-0.005	1.320	/			
2.000	+/-0.010	2.000	/			
0.340	+/-0.010	.340	/			
0.447	+/-0.010	.449	/		H-G	
Ø0.171	+0.005/-0.000	.174	/			
0.147	+/-0.010	.143	/			
0.376	+/-0.010	.379	/			
0.126	+/-0.010	.120	/			
0.063	+/-0.010	.054	/			
Ø0.166	+0.005/-0.000	.168	/			
0.911	+/-0.010	.908	/		H-G	
0.600	+/-0.010	.595	/			
0.125	+/-0.010	.128	/			
0.150	+/-0.010	.150	/			

Measured by: SH	Audited by: ONR	Prototype Approval:	N/A
Date: 11/04/28	Date: 11/04/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	
B	07.04.20	Dimensions update per Dwg Rev B	KJ/JLM	

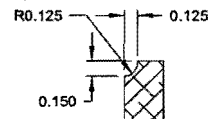
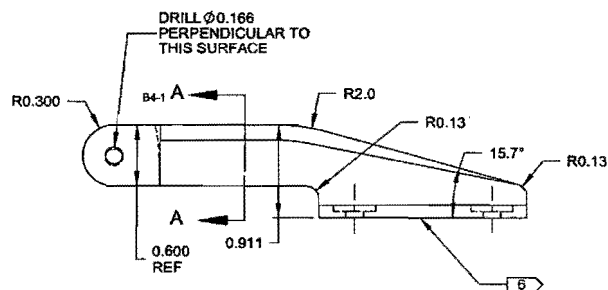
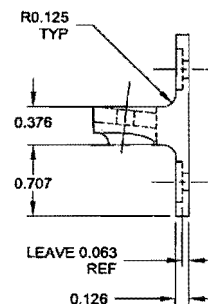
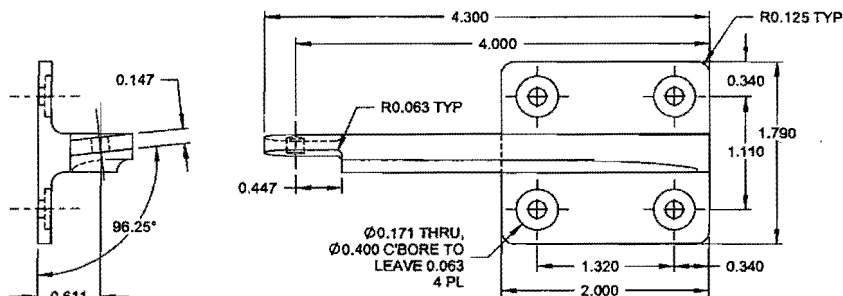
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NOTE: Date & initial all entries



B7-1 SECTION A-A

D2857-1 HINGE BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D2857-1" PER DART QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 0.11 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *66983*
PL11-03-3

RELEASED
2010-11-26

C	REFORMAT DWG, IDENTIFICATION BY MARKER WAS ENGRAVING (A8-1), REF PAR 10-040	CP	10.09.13
B	ADD THICKNESS, REDRAW W/ SOLIDWORKS	LE	06.08.28
A	NEW ISSUE	KE	98.12.14
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP		
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JP	D2857	SHEET 1 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	HINGE BRACKET	NTS
DATE	10.09.13	COPYRIGHT © 1988 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

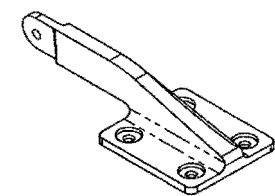
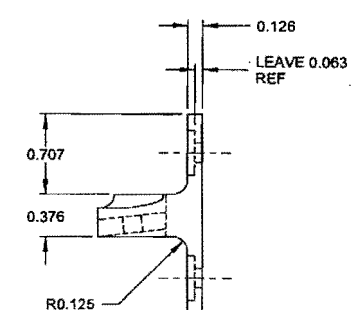
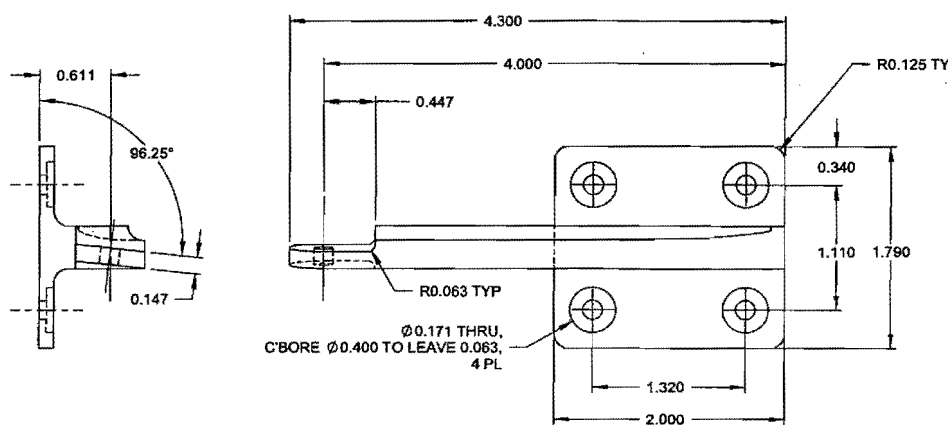
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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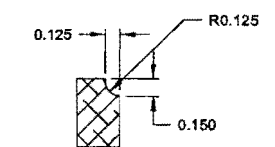
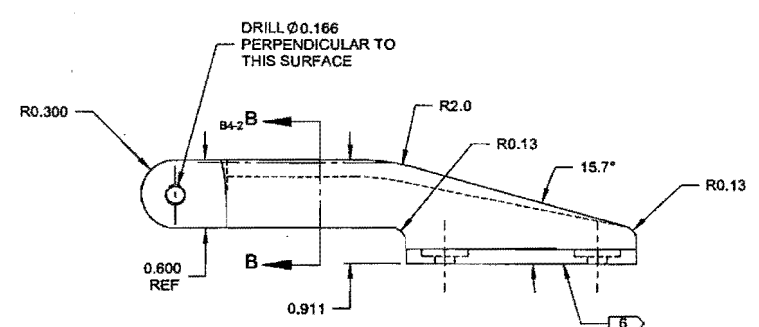
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



u/060983



B7-2 SECTION B-B

D2857-2 HINGE BRACKET

RELEASED
2010-11-26

- NOTES:**
- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221
REF DART SPEC M8081T6B
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: P/N "D2857-2" PER DART QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
 - 7) WEIGHT: 0.11 lbs

DESIGN	KE	DART AEROSPACE LTD	
DRAWN	97	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2857	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		HINGE BRACKET	NTS
DATE	10.09.13	<small>COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS LOANED ON THE EXPRESS CONDITION THAT IT NOT BE LOANED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries